

# Work Order ID 82563

April-03-12 8:34:40 AM

**\*82563\***

Page 1

Item ID: D2565-101 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Strut  
 Start Date: 03/04/2012 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 17/04/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/03 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2565	Rev E								
100	Punch ends and deburr as per dwg NC BRAKE	0.00							
<b>*100*</b>									
Brake NC	Memo	0.00							
Brake NC	Punch as per Dwg D2565 using DT 8313								
110	Small Fab	0.00							
<b>*110*</b>									
Small Fab	Memo	0.00							
Small Fab	Drill hole open to .316 Ø as per Dwg D2565 (one end only) Deburr								
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

8/12/05/10

9/12/05/10

(410)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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 Required Date: 17/04/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Powdercoat Powder Coating <i>M121134</i>	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel  Memo START TIME: <i>1:50</i> OVEN TEMPERATURE: <i>400 °F</i> FINISH TIME: <i>2:20</i>	0.00				<i>10 X</i>			<i>M/L 12/05/15</i>
140 <b>*140*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00				<i>10</i>			<i>12/5/15</i>
150 <b>*150*</b> Packaging Packaging	Identify as per dwg & Stock Location: <i>51252</i>  Memo	0.00				<i>10</i>			<i>54 12/5/15</i>

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**NOTE:** Date & initial all entries

**\*82563\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 03/04/2012    **Start Qty:** 10.00    **\*10\***

**Cust Item ID:**

**Required Date:** 17/04/2012    **Req'd Qty:** 10.00    **\*10\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

**Insp.  
Stamp**

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

12/5/17 ~~7~~  
ML5 12/05/16

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 82563

\*82563\*

Parent Item: D2565-101

\*D2565-101\*

Parent Item Name: Strut

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: F02.04.16Added dwg Rev.CING

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	340.6870	1.71	18			

\*M304TR0 750W 049\*

304 RD Tube .750 x .049W

\*\*

SB 12/05/12

Location

Loc Qty

Loc Code

MAT017

340.687

109314

9.333

111619

3

112187

4

112800

11

114852

2.75

116108

3

117797

0.75

120441

37.534

121170

269.32

M121666

21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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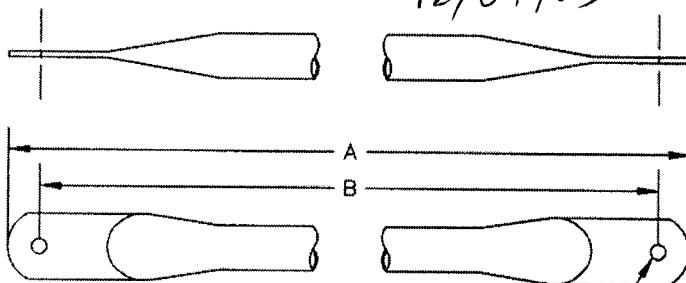
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED  
04.05.05

SHOP COPY  
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 82563 *MLJ*  
*12/04/03*



DIA 0.257 TO BE PUNCHED  
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TRO.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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